



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3319-3

Job Sheet 169847



Part No: D3319-3

Job Qty: 20 ea

Part Name: Full Length Wearplate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/31/17

Job Tracking No:

Due Date: 1/12/18

Created By: Linda Lacelle

Type: SOLD

Description:

Customer: Hydro One Networks Inc (CHYDR01)

Lake Simcoe Regional Airport RR #2, 224 Line 7, North Oro Station, ON, L0L 2E0 Canada ph:(705) 487-1771

Note: IPP: A 05.05.12 New issue KJ/JLM IPP Rev:B Now on Waterjet 06-10-03 JLM IPP REV:C 17.10.25 AS PER DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	1/11/18	1/11/18	0.00	0.00	Start Up Waterjet		SC 18/01/16
100	Waterjet	10 pcs	1/11/18	1/11/18	0.00	2.34	Waterjet1		SC 18/01/16
110	QC	10 pcs	1/11/18	1/11/18	0.00	0.00	QC2 Waterjet-2		SC 18/01/16
120	QC	10 pcs	1/11/18	1/11/18	0.00	0.00	QC8-2		10 18-01-17
140	Brake NC	20 pcs	1/11/18	1/11/18	0.12	1.40	Brake NC 1		SP
150	QC	20 pcs	1/11/18	1/11/18	0.00	0.00	QC5		A
160	Autoweld 1	20 pcs	1/12/18	1/12/18	0.00	6.37	Automated welding		17 DAS
170	QC	20 pcs	1/12/18	1/12/18	0.00	0.00	QC10		38 DAS
180	QC	20 pcs	1/12/18	1/12/18	0.00	0.00	QC5		38
190	Powdercoat	20 pcs	1/12/18	1/12/18	0.00	0.00	Powdercoat3		DT 18-01-20
200	QC	20 pcs	1/12/18	1/12/18	0.00	0.00	QC3		18-1-22
210	Packaging	20 pcs	1/12/18	1/12/18	0.00	0.00	Packaging3-1	17 260 B	17 18-01-23
220	QC21-SA	20 Ea	1/12/18	1/12/18	0.00	0.00	QC21		M

Part Op 100 - 1-Cut as per Dwg D3319 Dwg Rev: D Prog Rev: D 2-Deburr if necessary
Descriptions: 140 - Form using DT8326 & DT8261 as per Dwg D3319

160 - 8259 Hardcoat Rod

190 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE.

BATCH: 138705 exp: 12/18

210 - Identify on inside surface using a permanent fine point marker with the following:

5032213

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S18GA	33	136	0	0

24725
52.50

DART
AEROSPACE
S032833



Full Length Wearplate

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

PART NO: D3319-3
Original Serial #: S032833
Revision:
Operation:
Change No:

Start up Operation 01/16/18
Job No: 169847

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	0.190inches + 0.005 - 0.001	0.195 0.189	0,192	
2	Wearplate	0.500inches + 0.006 - 0.001	0.506 0.499	0,501	
3	Wearplate	0.316inches ± 0.010	0.326 0.306	0,318	
4	Wearplate	0.607inches ± 0.010	0.617 0.597	0,610	
5	Wearplate	2.940inches ± 0.030	2.970 2.910	2,948	
6	Wearplate	2.690inches ± 0.030	2.720 2.660	2,710 2,707	
7	Wearplate	3.527inches ± 0.010	3.537 3.517	3,528	
8	Wearplate	4.520inches ± 0.030	4.550 4.490	4,522	
9	Wearplate	5.063inches ± 0.010	5.073 5.053	5,068	
10	Wearplate	6.160inches ± 0.030	6.190 6.130	6,16	
11	Wearplate	0.600inches ± 0.030	0.630 0.570	0,601	
12	Wearplate	8.690inches ± 0.010	8.700 8.680	8,692	
13	Wearplate	30.790inches ± 0.010	30.800 30.780	30,792	
14	Wearplate	52.880inches ± 0.030	52.910 52.850	52,881	
15	Wearplate	62.770inches ± 0.010	62.780 62.760	62,772	
16	Wearplate	74.420inches ± 0.010	74.430 74.410	74,421	
17	Wearplate	75.520inches ± 0.030	75.550 75.490	75,525	
18	Wearplate	0.050inches ± 0.010	0.060 0.040	0,048	

PD

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☒ Quality ☐ Other ☐																																																																																																																																			
Date : 18/1/19		Step #: 190		QTY Effective :		MRB (QSI042) Approval DAS 12 9-89 18/1/19																																																																																																																																	
Description Work Order Deviation				Disposition																																																																																																																																			
QSI calls for Axalta adhesion promoter. Test by Eng (CP) showed that the Axalta product provided no measurable improvement. Axalta adhesion promoter is time consuming to apply.				Acceptable to not use Axalta adhesion promoter.																																																																																																																																			
								Completed By DAS 12 9-89 18/1/19																																																																																																																															
								Lead hand / Supervisor Approval Verification																																																																																																																															
				QC / QA Coordinator Approval																																																																																																																																			
Root Cause <table style="width:100%;"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table>		Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	FAULT CATEGORY <table style="width:100%;"> <tr><td>Pressure/Forced</td><td>☐</td><td>Temperature/Cure</td><td>☐</td><td>Power Loss/Surge</td><td>☐</td><td>Positioned Wrong</td><td>☐</td></tr> <tr><td>Bending</td><td>☐</td><td>Set-up</td><td>☐</td><td>Folio/Program</td><td>☐</td><td>Outside Dimensions</td><td>☐</td></tr> <tr><td>Centre Not Concentric</td><td>☐</td><td>BOM/Route</td><td>☐</td><td>Grain</td><td>☐</td><td>Over/Under tolerance</td><td>☐</td></tr> <tr><td>Cracks</td><td>☐</td><td>Broken/Damage/Defect</td><td>☐</td><td>Weld</td><td>☐</td><td>Part Incorrect</td><td>☐</td></tr> <tr><td>Crimp/Kink/Ripple/Wave</td><td>☐</td><td>Inspection Incomplete/Unqualified</td><td>☐</td><td>Wrong Stock Pulled</td><td>☐</td><td>Part Lost/Missing</td><td>☐</td></tr> <tr><td>Cuffs</td><td>☐</td><td>Contamination</td><td>☐</td><td>Out of Sequence</td><td>☐</td><td>Part Moved</td><td>☐</td></tr> <tr><td>Crushing</td><td>☐</td><td>Countersink</td><td>☐</td><td>Off-set</td><td>☐</td><td>Drawing</td><td>☐</td></tr> <tr><td>Heat Treat</td><td>☐</td><td>Cut Too Short</td><td>☐</td><td>Mislabeled</td><td>☐</td><td>Finish</td><td>☐</td></tr> <tr><td>Wave/Twist in Tube</td><td>☐</td><td>Instructions Incomplete/Unclear</td><td>☐</td><td>Fit/Function</td><td>☐</td><td>Misread</td><td>☐</td></tr> <tr><td>Marks/Chatter</td><td>☐</td><td>Drill Holes</td><td>☐</td><td>Misaligned/off center</td><td>☐</td><td>Turning Sequence</td><td>☐</td></tr> </table>						Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Environment	☐	No Re-verification	☐																																																																																																																																				
Design	☐	Operator	☐																																																																																																																																				
Doc/Data	☐	Offset/Setup	☐																																																																																																																																				
Equip/Tooling	☐	Supplier	☐																																																																																																																																				
Handling/Pre	☐	Training	☐																																																																																																																																				
Material	☐	Use for Testing	☐																																																																																																																																				
Internal Transport	☐	Poor Information	☐																																																																																																																																				
Tribal Knowledge	☐	Rushing	☐																																																																																																																																				
LOA	☐	Product Improvement	☐																																																																																																																																				
Substation	☐	Process Improvement	☐																																																																																																																																				
Past Expiry Date	☐	Manufacturing Process	☐																																																																																																																																				
Misidentified	☐	Past Due	☐																																																																																																																																				
Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐																																																																																																																																
Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐																																																																																																																																
Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐																																																																																																																																
Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐																																																																																																																																
Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐																																																																																																																																
Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐																																																																																																																																
Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐																																																																																																																																
Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐																																																																																																																																
Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐																																																																																																																																
Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐																																																																																																																																
		OTHER :																																																																																																																																					